

Work Order ID 52939

October 19, 2009 11:03:31 AM



Page 1

Item ID: D3622-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Ball Stud

Start Date: 10/19/09 Start Qty: 16.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 16.00

Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *09-10-19* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3622	B

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Tum as per Dwg D3622 & Folio FA846

Dwg Rev: *AS*

Folio Rev: *A*

SA 09/10/20

Deburr as per Dwg

18 *0*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SA 09/10/20

18 *0*

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Page 2

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120 QC8- Inspect parts - second check

0.00



QC Memo

0.00

Quality Control

130 Identify as per dwg & Stock Location: 118

0.00



Packaging Memo

0.00

Packaging

140 QC21- Final Inspection - Work Order Release

0.00



QC Memo

0.00

Quality Control

18

09/10/21 (18)

09/10/21
ME 09-10-21

Picklist Print

October 19, 2009 11:03:35 AM

Page 1

Work Order ID: 52939

Parent Item: D3622-3RevB-PRELIM

Parent Item Name: Ball Stud


Comments:

Start Date: 10/19/09

Required Date: 11/02/09

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M303H0.500 		Purchased	No			100	f	158.6320	1.8189			
303 HEX BAR .500												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	158.632	
109778	133.612	
109846	25.02	

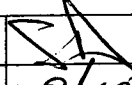
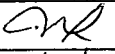
227 SA 00/10/20



DART AEROSPACE LTD		Work Order: 52939
Description: Ball Stud		Part Number: D3622-3
Inspection Dwg: D3622	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

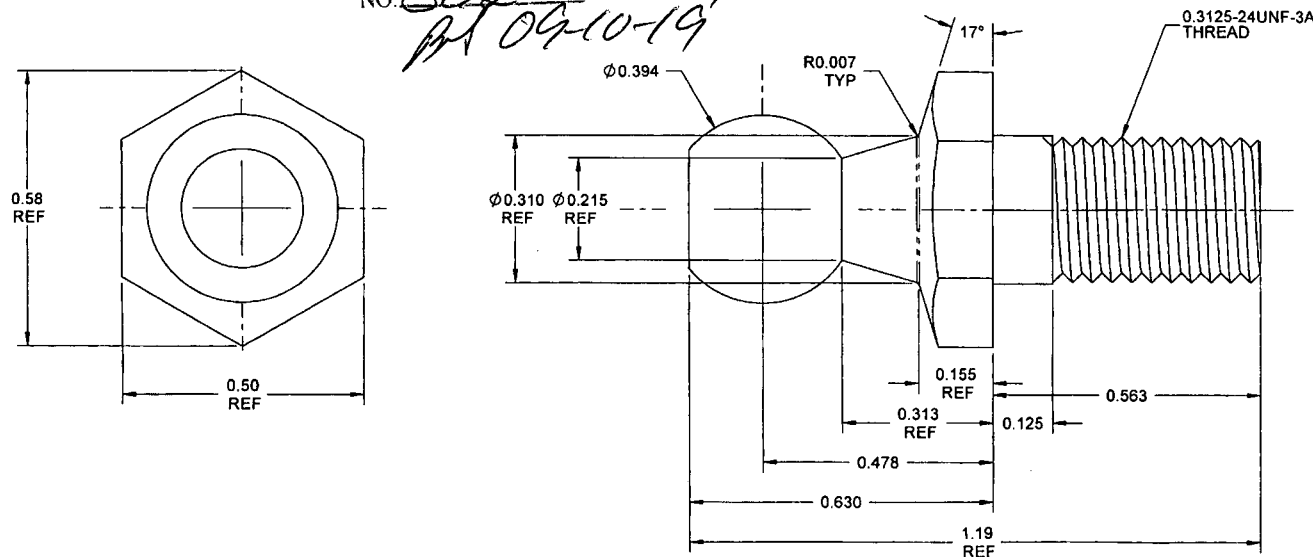
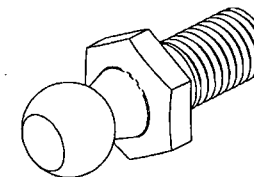
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.19	+/-0.030	1.199	/			
0.630	+/-0.010	0.630	/			
0.563	+/-0.010	0.563	/			
0.125	+/-0.010	0.130	/			
0.155	+/-0.010	0.155	/			
Ø0.310	+/-0.010	Ø0.312	/			
Ø0.215	+/-0.010	Ø0.215	/			
Ø0.394	+/-0.010	Ø0.394	/			
R0.007	+/-0.010	R0.008	/			
0.3125-24UNF-3A	+0.000/-0.001					
Over wires	Min = 0.3335					
	Max = 0.3363					
Major Ø	Max = 1.87 Min = 1.68	1.85	/			
M.O.W.	Max = 2.14 Min = 2.12	2.125	/			

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 09/10/20	Date: 09/10/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD 	

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WORK ORDER

NO. *3622-52939*
09-10-19



RELEASED
2009-10-08

D3622-1 BALL STUD

NOTES:

- 1) MATERIAL: AISI 303 HEX BAR
REF DART SPEC M303H0.500
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3622-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

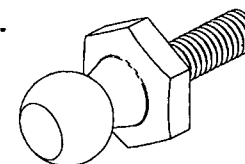
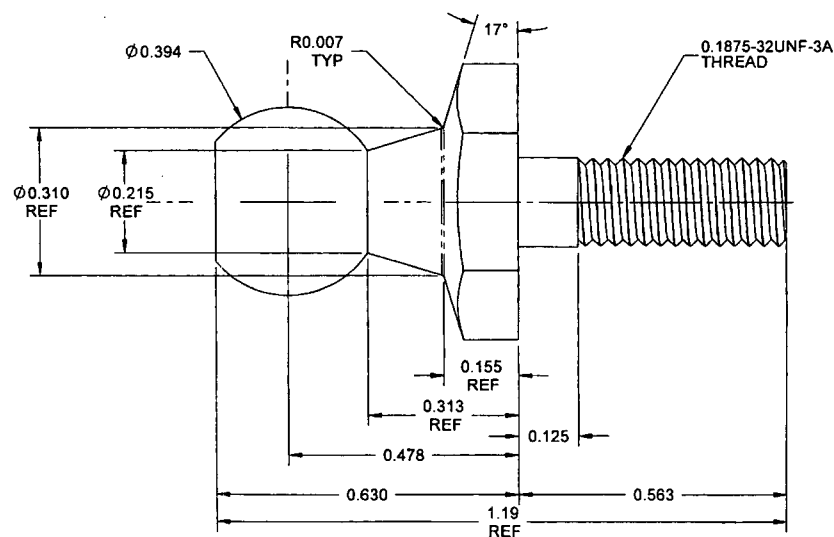
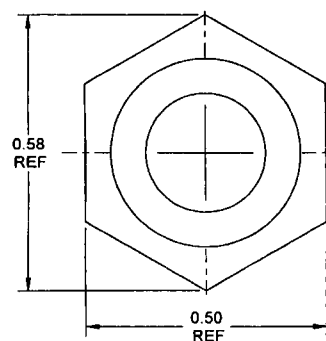
B	ADD-3 (SHEET 2)	MB	09.09.18
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.09.18		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3622** REV. B
SHEET 1 OF 2

TITLE **BALL STUD** SCALE NTS

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WORK ORDER NO. 5293.9

D3622-3 BALL STUD

RELEASED
2009-10-08
WP

NOTES:

- 1) MATERIAL: AISI 303 HEX BAR
REF DART SPEC M303H0.500
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3622-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AS	D3622	SHEET 2 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BALL STUD	NTS
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